

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009922**Date Inspected:** 12-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Le Hong Fie.	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	Tower Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 11, West tower, Lift 2, 55M(Bottom), BC Corner Diagonal Plate.

During random visual inspection at West Shaft, Lift 2, B/C Corner Capping Plate; this Caltrans Quality Assurance (QA) Inspector observed "Crack Like" indications at the Weld WSD1-TL6K/L-57. The indications were shown to ZPMC and ABF QC Inspectors. This Caltrans Quality Assurance (QA) Inspector also confirmed these indications by Magnetic Particle Testing. This Issue has Incident Report written on same date.

Bay11, West Tower, Struts Repair.

Repair gouge out noticed on strut weld Identified as WD1-A6003-8-7B, 9A. See attached picture for details.

Bay11, West Tower, Lift 3, 89M Diaphragm.

SMAW Repair welding (ZPMC VT-Repair)of weld joint WSTL3-4D/K-58; located on Bay11, West Tower, Lift 3. Welders are identified as 058026; ZPMC Quality Control Inspector (QC) is identified as Le Hong Fie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-1G(1F)-Repair.

Bay11, West Tower, Lift 1.

1) AB/F Finished Visual Testing(VT) on bottom side Buttering Area. ZPMC Grinding VT-Repairs.

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2) Drilling holes on Doubler Plates between 23M, 33M, 38M, 47.6M Double Diaphragms on Skin E.

This QA Inspector carried out NDE on following
Bay 11, West Tower, Spare Struts.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as WD1-A6001-2.
GREEN TAG # 9275.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
